

Work Order ID 54007

November 25, 2009 2:15:55 PM

Page 1

Item ID: D3319-1

Accept

Setup Start

Revision ID: B

Stop

Item Name: Wearplate

Start Date: 11/26/2009 Start Qty: 12.00

Cust Item ID:

Required Date: 12/4/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: MF Date: 09-11-25 Tooling:

Date:

Run Start

QC: Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
----------	--------------

D3319	Rev B
-------	-------

100 FLOW WATER JET 0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3319 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

B 9-12-7

110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC

Memo

0.00

Quality Control

B 9-12-7

120 QC8- Inspect parts - second check 0.00



QC

Memo

0.00

Quality Control

2) 5 or 12/07

(712) 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Debur if necessary

u / as

0.00

0.00

140



Brake NC

Brake NC

NC BRAKE

Memo

1- Form using DT8326 & DT8261 as per Dwg D3319Rev: B □2- Form
flat on press using DT8776 block

0.00

0.00

12 0

SB 09/12/08

150



QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

=> 09/12/08

(412) /

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID:	D3319-1	Accept		Setup	Start	
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Item Name:	Wearplate					
Start Date:	11/26/2009	Start Qty: 12.00		Cust Item ID:		
Required Date:	12/4/2009	Req'd Qty: 12.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Large Fab	Large Fab	0.00							
Large Fab	Memo	0.00							
Large Fab	1- Layout weld location as per Dwg D3319 using jig D3319-1T3□2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: <u>B</u> □ Qty Part Number Description Batch□A/R N/A 7560 Hardcoat Rod <u>M113078</u>								
170  QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							
180  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

(BX)

SP 09 12 14

⇒ S 02/12/14

x12

⇒ S 02/12/14

(x12)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

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Revision ID: B				Stop	
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Start Date: 11/26/2009	Start Qty: 12.00		Cust Item ID:		
Required Date: 12/4/2009	Req'd Qty: 12.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3 <i>M112588</i> Memo START TIME: <i>10:40</i> <i>322</i> <input type="checkbox"/> FINISH TIME: <i>11:10</i> <input type="checkbox"/> OVEN TEMPERATURE:	0.00 0.00							
				<i>BL 09-12-14</i>		<i>(12)</i>			
200 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
				<i>WD 09/12/14</i>		<i>x12</i>			
210 Packaging Packaging Packaging	Packaging Memo Identify on inside surface using a permanent fine point marker with the following: <input type="checkbox"/> TCCA-PDA, Dart Aerospace Ltd. <input type="checkbox"/> P/N: D3319-1, B/N: BXXXXX <input type="checkbox"/> For Product Eligibility see PDA05-18 <input type="checkbox"/> and Stock <input type="checkbox"/> Location: <i>51497</i>	0.00 0.00							
						<i>x12</i>			
				<i>WD 09/12/15</i>					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Page 5

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/17

u 09.12.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

November 25, 2009 2:15:55 PM

Page 1

Work Order ID: 54007



Parent Item: D3319-1RevB



Parent Item Name: Wearplate

Start Date: 11/26/2009

Required Date: 12/4/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M1010S18GA

Purchased

No

100

sf

61.1456

7.9326



1010/1025 SHEET .048

B9-D-7

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

61.1456

106603

1

109022

3

109948

3

111964

54.1456

111964

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

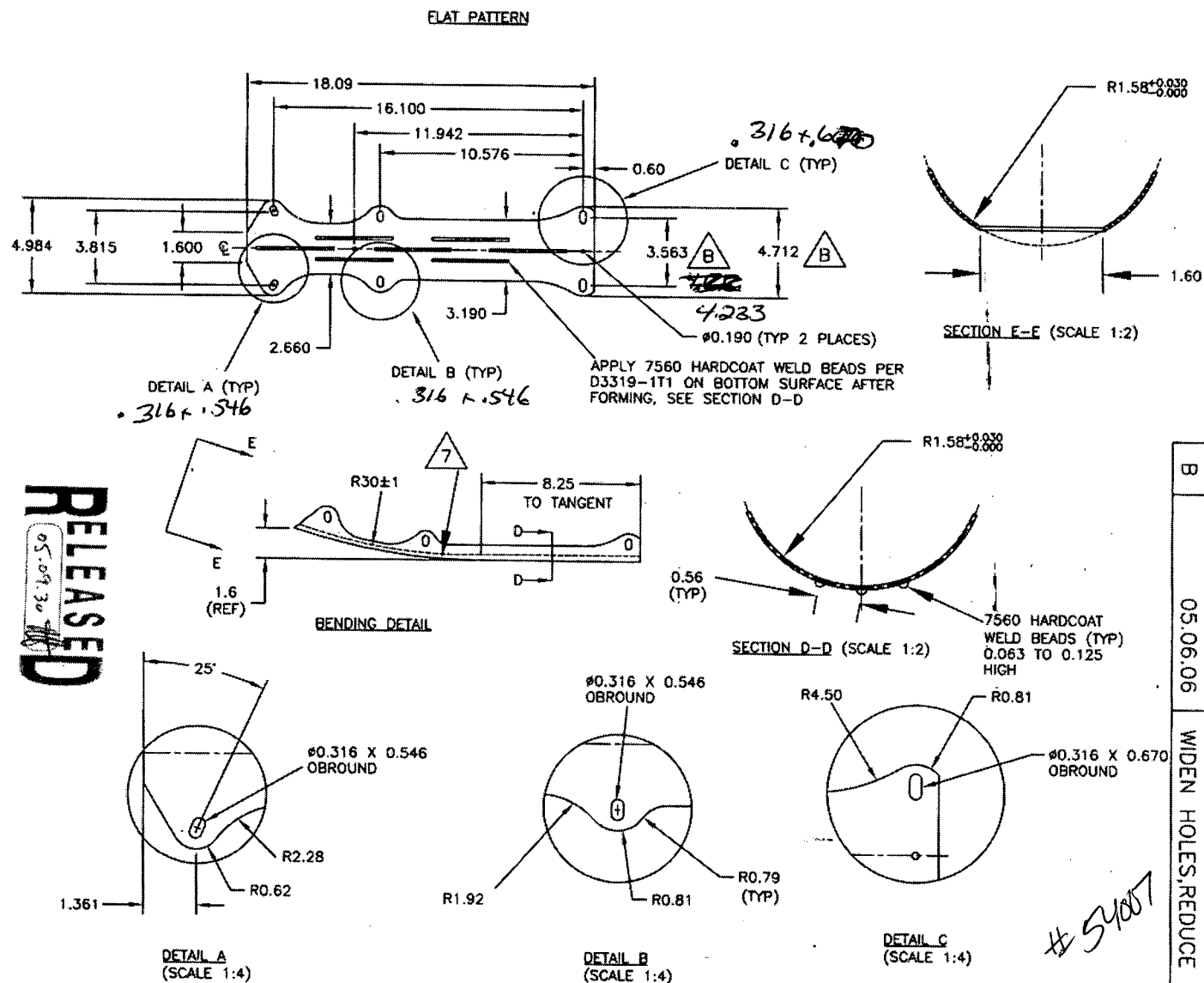
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
P1	P1	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
#	#	D3319
DATE	TITLE	REV. B
05.06.06	WEARPLATE	SHEET 1 OF 5
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7
		SCALE 1:8

RELEASED
05.09.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

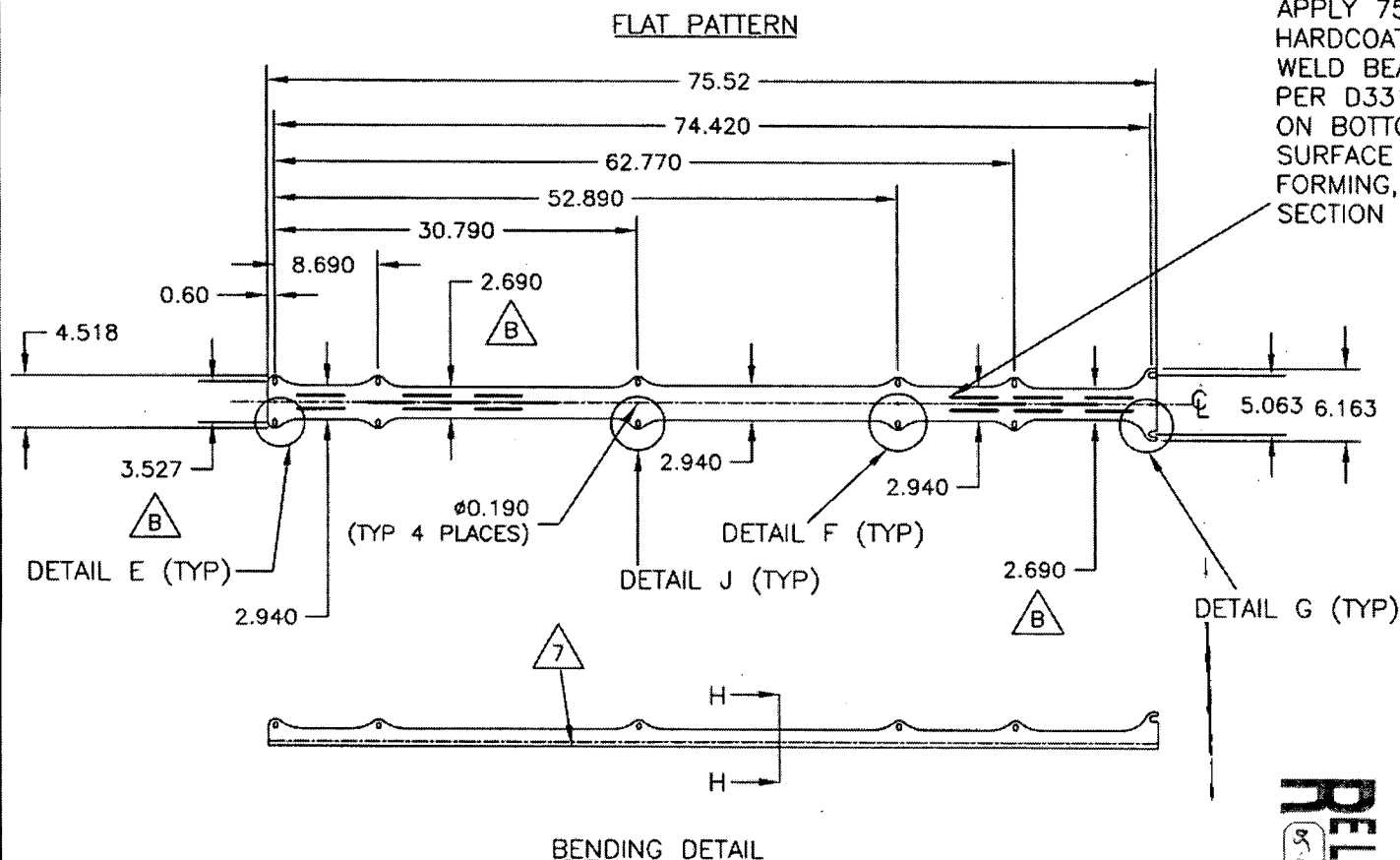
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. B
05.06.06	D3319	SHEET 2 OF 5
	WEARPLATE	SCALE
		1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H



D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05-01-30

#54007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

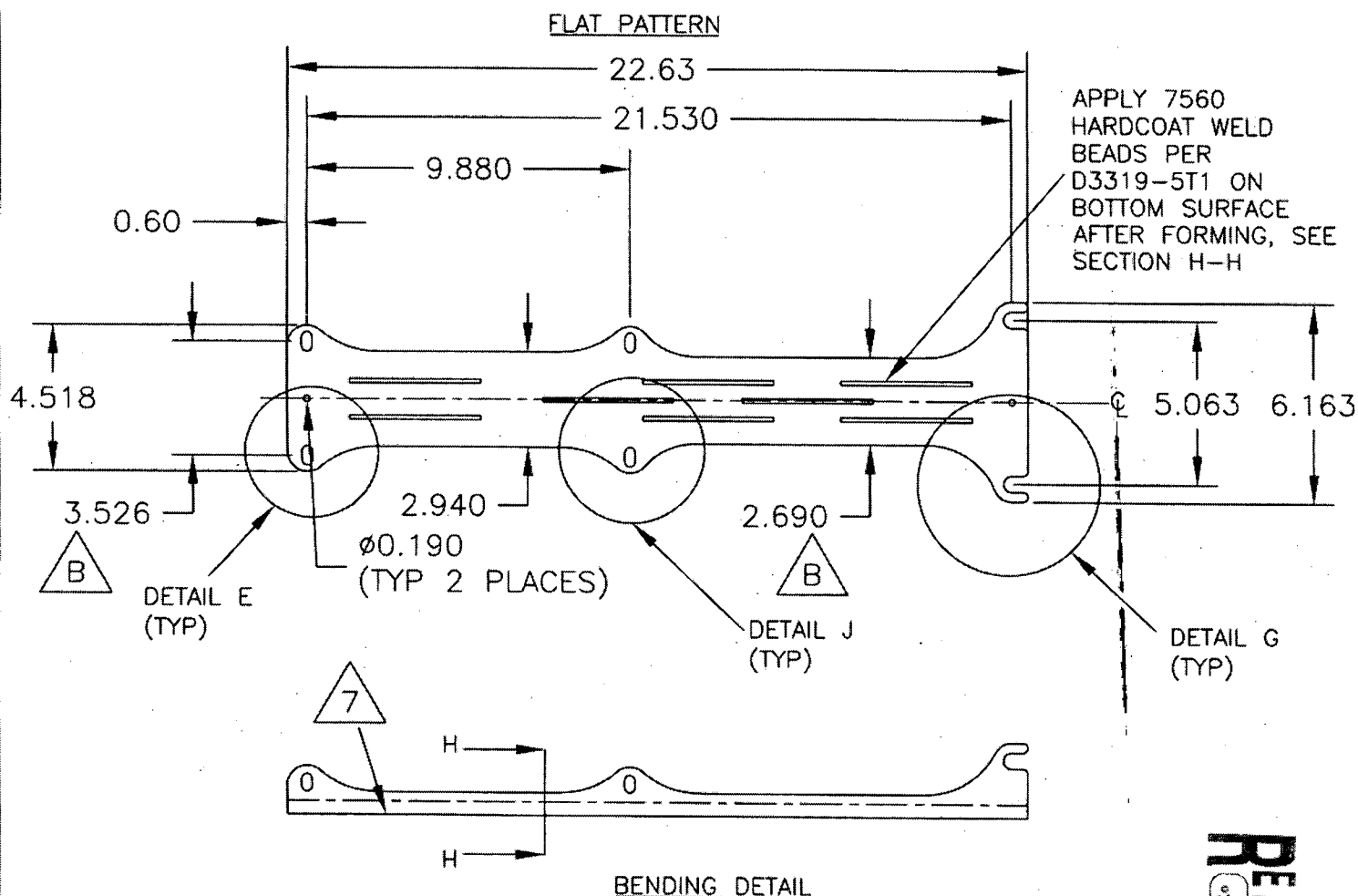
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	D411	DRAWING 01	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	D3319	SHEET 3 OF 5
DATE	05.06.06			TITLE	WEARPLATE
				SCALE	1:5



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1015-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

05-29-30

#54005

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

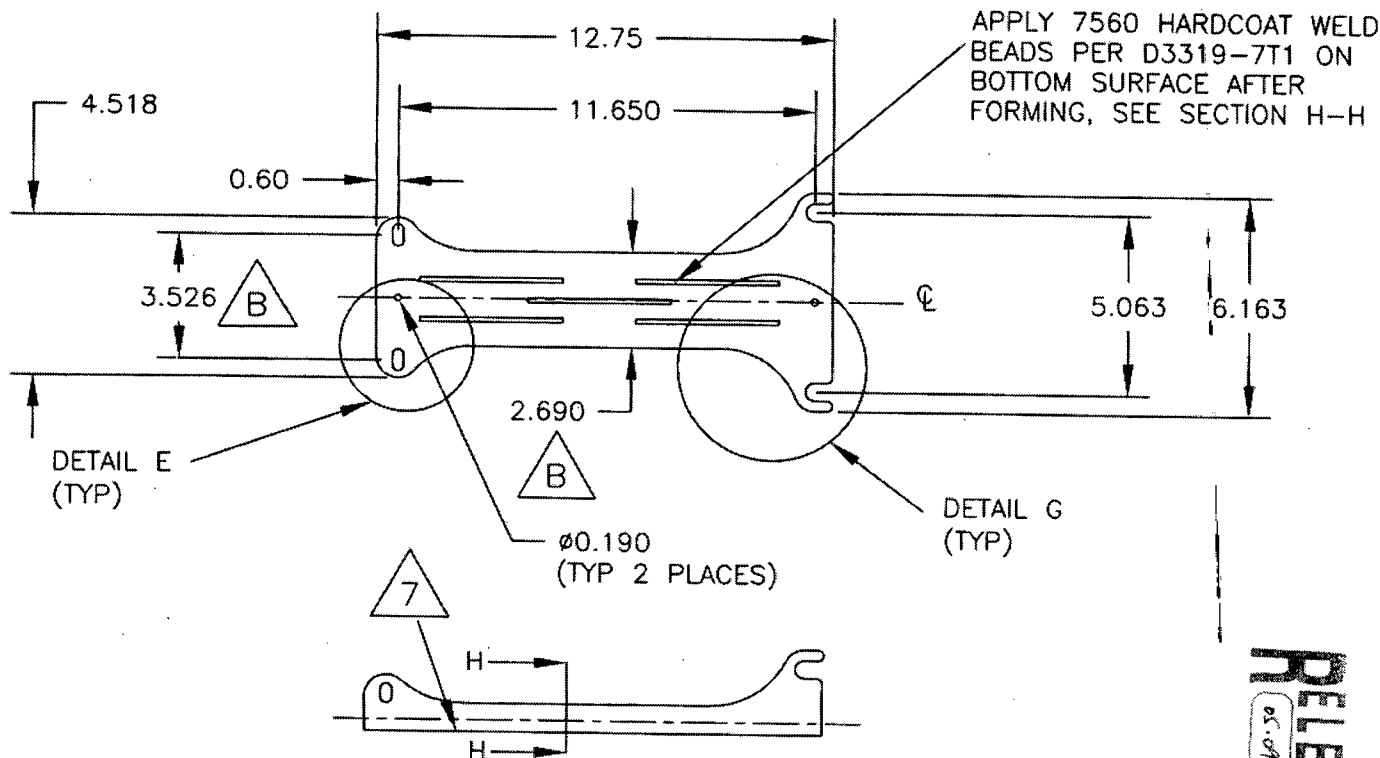
DART

DESIGN	PH	DRAWN BY	GH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	GH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 4 OF 5
		SCALE	1:5	

RELEASED
05.09.30

#54007

FLAT PATTERN



BENDING DETAIL

D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

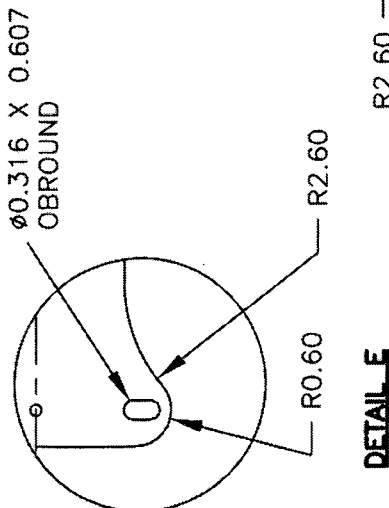
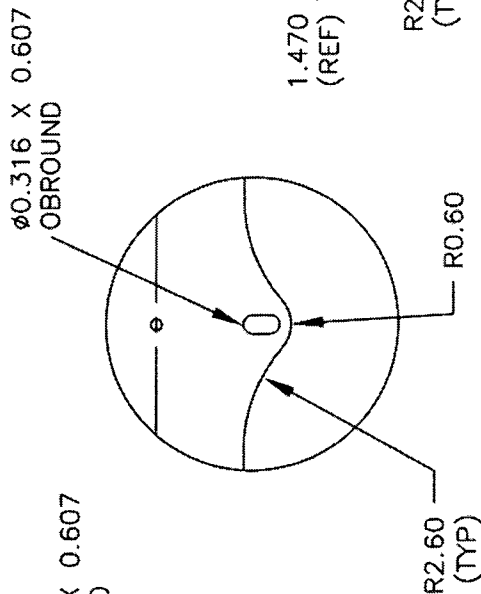
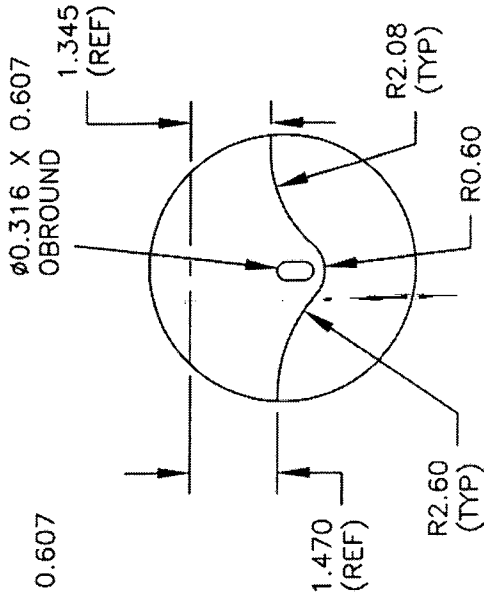
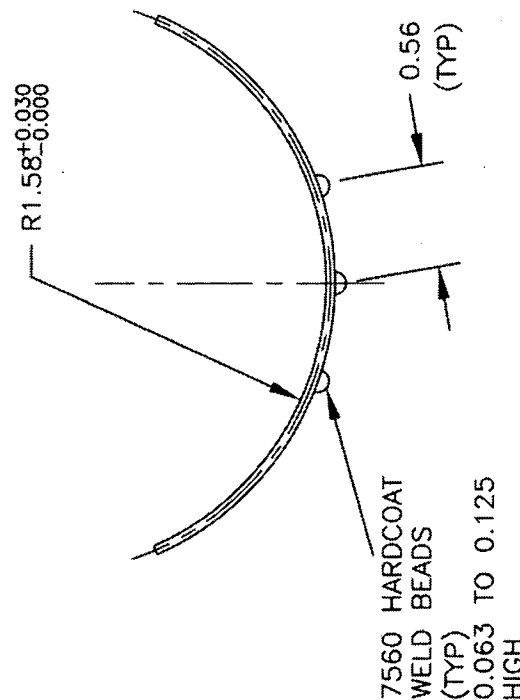
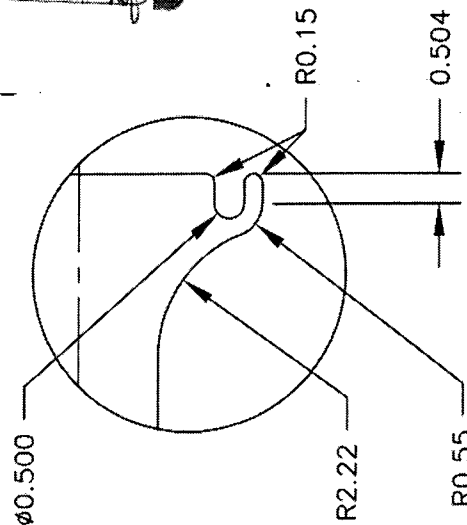
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NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3

**RELEASED**
05.09.30

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